

Work Order ID 57823

April 16, 2010 10:50:17 AM



Page 1

Item ID: D3911-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Eyebolt Receiver

Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference: *10.04.16.*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.885" long

SP 10/04/19

6 0

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-MILL as per folio FA917 & dwg.

FOLIO REV: *AA*

DWG REV: *C*

2-Deburr as required

only 10/04/20

6 0



5S continued...

- **Standardize (Seiketsu) (清潔):** Standardizing. This refers to standardized work practices. This means operating in a consistent and standardized fashion. Everyone knows exactly what his or her responsibilities are.
- **Sustain (Shitsuke) (躰):** Sustaining. Refers to maintaining and reviewing standards. Once the previous 4S's have been established they become the new way to operate. Maintain the focus on this new way of operating, and do not allow a gradual decline back to the old ways of operating.

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Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

amb 10/04/20

6 0

Quality Control

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 95

0.00

Packaging

Memo

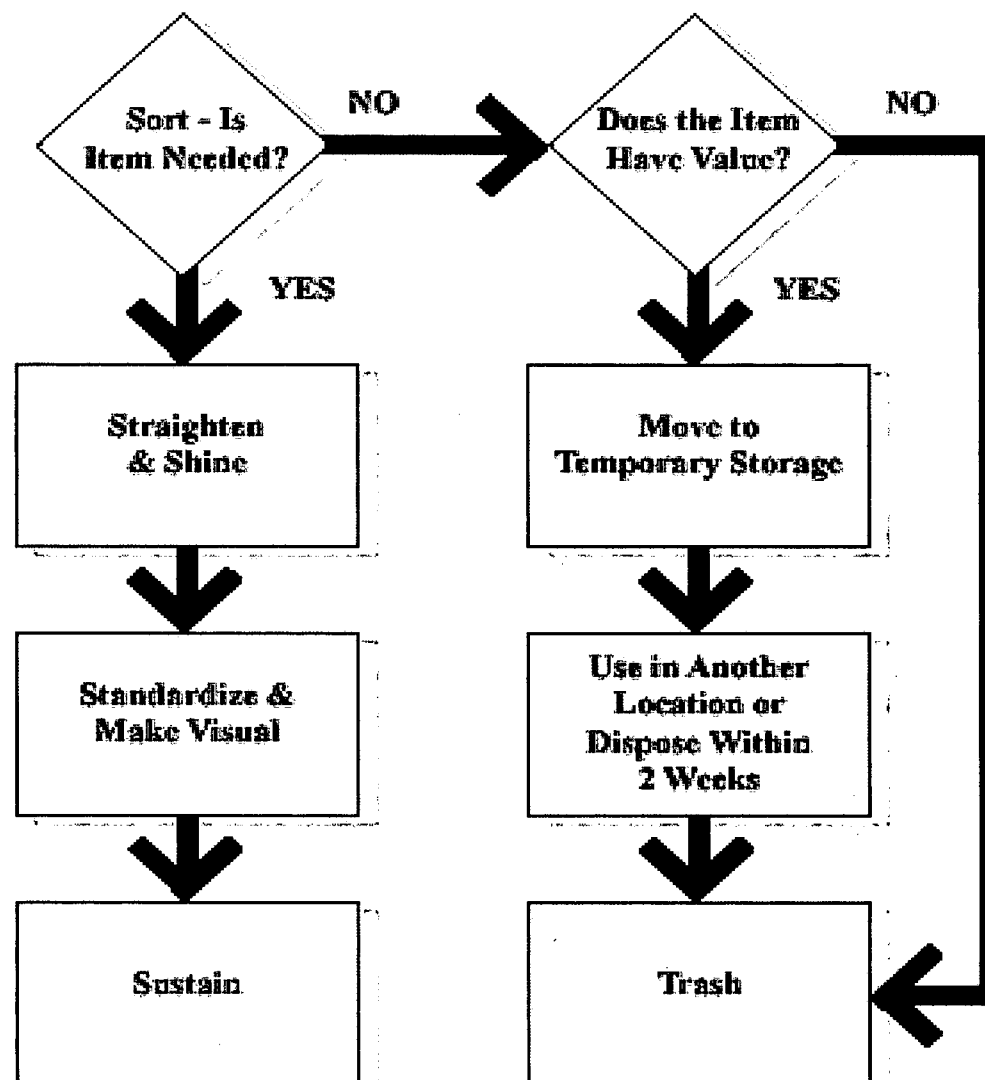
0.00

Packaging

104-21 sf (G)

The following chart shows the repeatable 5S system.

5S Flow Chart



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Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

60604/22 *[Signature]*
MF
10-4-22

Remember....

- Lean is war to WASTE.
- Waste is an activity or output that ***adds cost but does not add value***
- You have to get into a mindset of identifying and eliminating all wastes.

The 7 deadly wastes

- | | |
|--|--|
| 1. <i>Overproduction</i> | 2. <i>Rework</i> |
| 3. <i>Transportation</i> | 4. <i>Inappropriate / over Processing</i> |
| 5. <i>Unnecessary Inventory</i> | 6. <i>Delays / Waiting</i> |
| 7. <i>Unnecessary Motions</i> | |

Picklist Print

April 16, 2010 10:50:16 AM

Page 1

Work Order ID: 57823



Parent Item: D3911-3



Parent Item Name: Aft Eyebolt Receiver

Comments: IPP RevA: New issue DD verified by:EC
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	5.8579	1.6421			
303 BAR 2" X 1.750"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT53

5.8579

113310

5.8579

1.6421

28 10/04/19

5S basics

- **Sort (Seiri) (整理):** Sorting. Refers to the practice of going through all the tools, materials, etc., in the work area and keeping only essential items. Everything else is stored or discarded. This leads to fewer hazards and less clutter to interfere with productive work.
- **Set in order (Seiton) (整頓):** Simplifying. Focuses on the need for an orderly workplace. "Orderly" in this sense means arranging the tools and equipment in an order that promotes work flow. Tools and equipment should be kept where they will be used, and the process should be ordered in a manner that eliminates extra motion.
- **Shine (Seisō) (清掃):** Sweeping, Systematic Cleaning, or Shining. Indicates the need to keep the workplace clean as well as neat. At the end of each shift, the work area is cleaned up and everything is restored to its place. The key point is that maintaining cleanliness should be part of the daily work - not an occasional activity initiated when things get too messy.

DART AEROSPACE LTD		Work Order: 57823
Description: AFT EYEBOLT RECEIVER		Part Number: D3911-3
Inspection Dwg: D3911 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

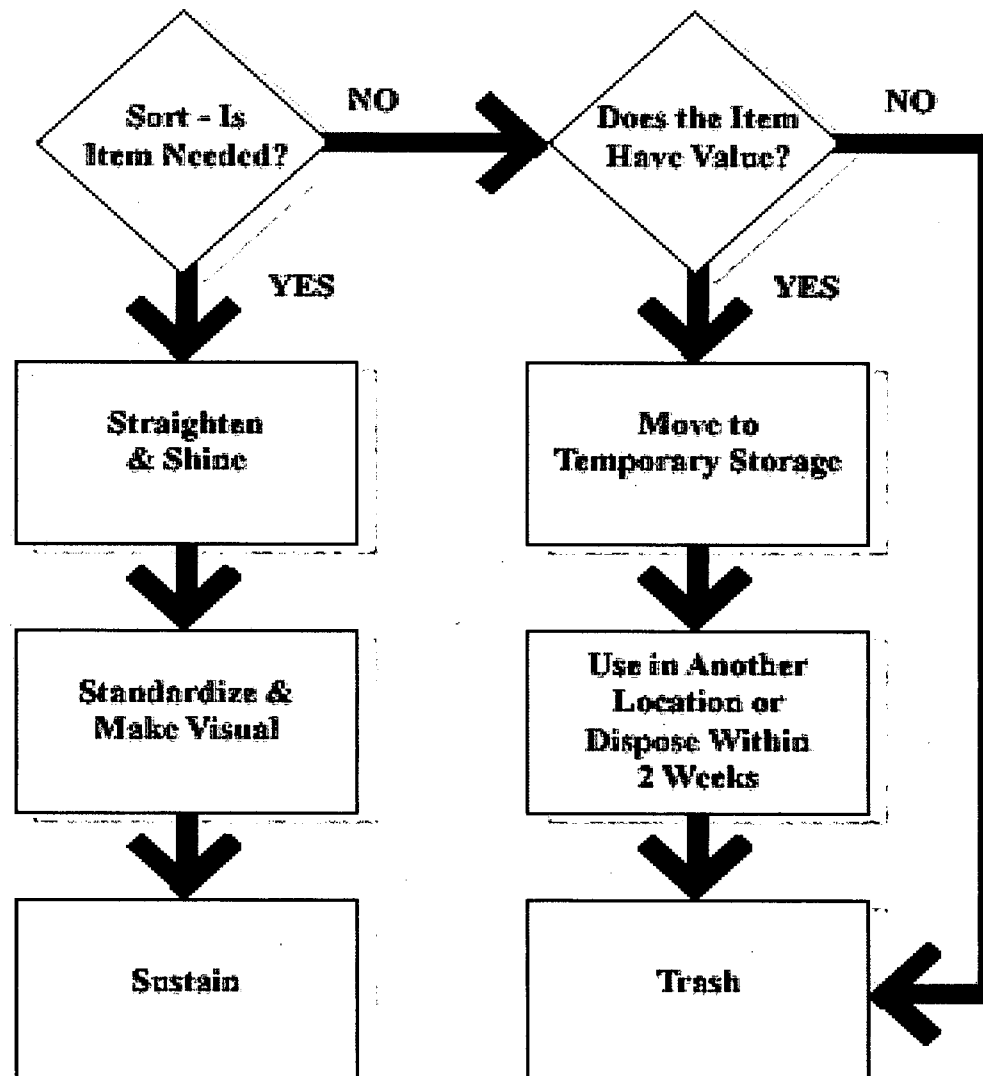
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1.250	$\pm .010$	1.248	—			
.09X45°	$\pm .030 \times \pm 1/2^\circ$.085X45°	—			
1.00	$\pm .030$	1.000	—			
.500	$\pm .005$.500	—			
R.13	$\pm .030$	R.130	—			
Ø.129	$\pm .005$ $\pm .001$	Ø.129	—			
R.19	$\pm .030$	R.190	—			
.960	$\pm .010$.965	—			
.09X45°	$\pm .030 \times \pm 1/2^\circ$.100X45°	—			
Ø.257	$\pm .006$ $\pm .001$	Ø.259	—			
.350	$\pm .010$.350	—			
2.76	$\pm .030$	2.762	—			
1.10	$\pm .010$	1.100	—			
.800	$\pm .000$ $\pm .010$.788	—			
.225	$\pm .010$.223	—			
1.80	$\pm .030$	1.796	—			
.65	$\pm .030$.652	—			
.625	$\pm .010$.624	—			
.09X45°	$\pm .030 \times \pm 1/2^\circ$.100X45°	—			
Ø.734	$\pm .010$ $\pm .000$	Ø.736	—			

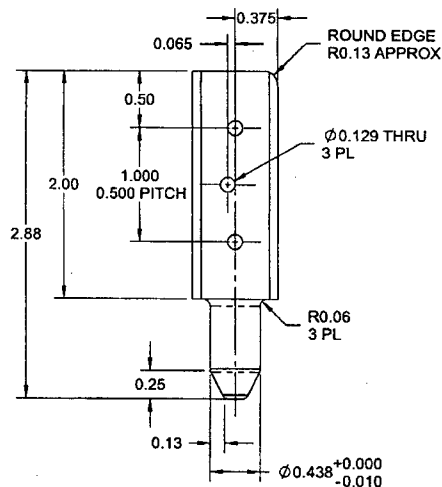
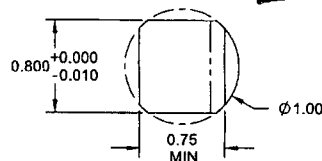
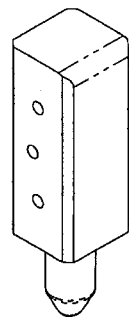
Measured by: <i>mf</i>	Audited by: <i>MM</i>	Prototype Approval:	N/A
Date: 10/04/20	Date: 10/04/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

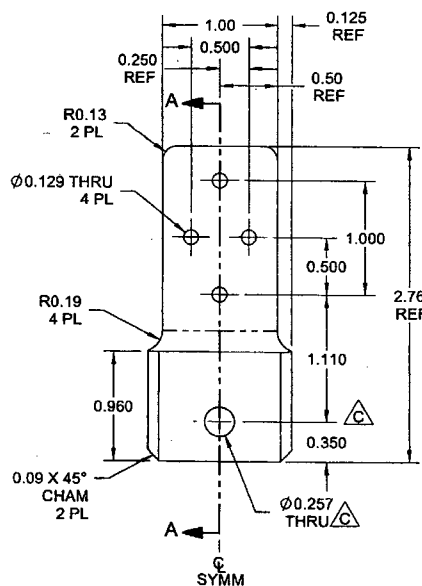
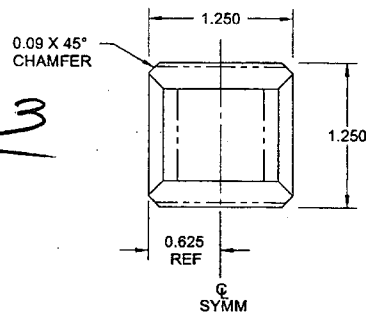
The following chart shows the repeatable 5S system.

5S Flow Chart

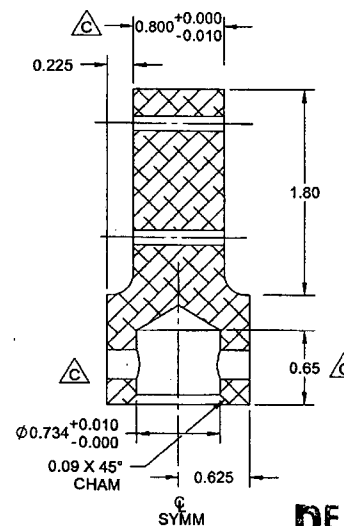
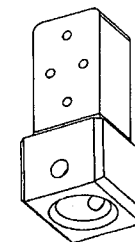




D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-04-14
JW

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.73 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3911	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Lean Training Event

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EAGLE

